



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6205G25031-3G-1
Job Sheet 168583



Part No: RBW6205G25031-3G-1

Job Qty: 1 ea

Part Name: Clamp



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/17/17

Job Tracking No:

Due Date: 11/30/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW6205G25031-3G REV B SHEET 2 IPP Rev.A 17.09.06 New issue DP Verify DD IPP 17.11.14 Rev B DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/30/17	11/30/17	0.00	0.00	Start Up Container		J.S. 18-01-23
110	CNC Vertical Machining	1 pcs	11/30/17	11/30/17	0.00	0.00	HAAS 1		G.A. 18-01-23
120	QC	1 pcs	11/30/17	11/30/17	0.00	0.00	QC2		J.S. 18-01-23
130	QC	1 pcs	11/30/17	11/30/17	0.00	0.00	QC8		J.S. 18-01-23
140	HandFinish	1 pcs	11/30/17	11/30/17	0.00	0.00	HandFinish1		
150	QC	1 pcs	11/30/17	11/30/17	0.00	0.00	QC5		D. 18-01-23
160	Packaging	1 pcs	11/30/17	11/30/17	0.00	0.00	Packaging3		D. 18-01-23
170	QC21-SA	1 Ea	11/30/17	11/30/17	0.00	0.00	QC21		

Part Op 110 - Machine as per DWG. Folio _____

Descriptions: 140 - Paint machined surfaces

150 - Ink stamp T/N and batch number as per DWG.

DAS
21
9-59

JAN 23 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	A-205	1	0	0	0

Part Specifications

Specifications could not be found.

Plex 11/17/17 11:44 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

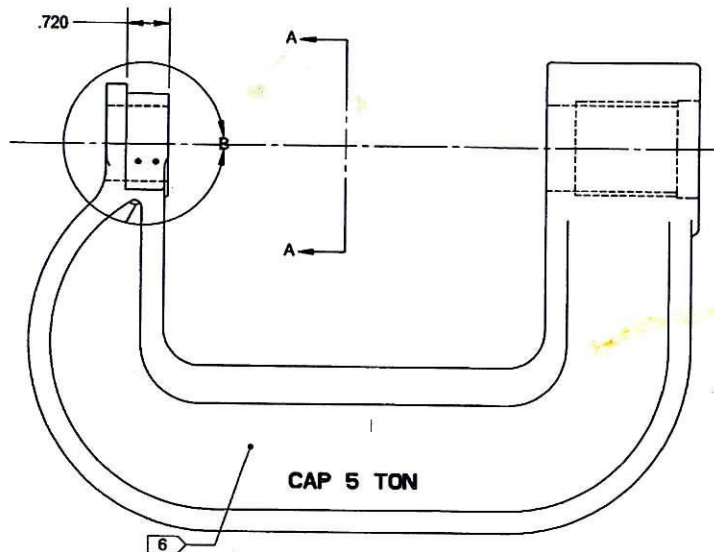
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

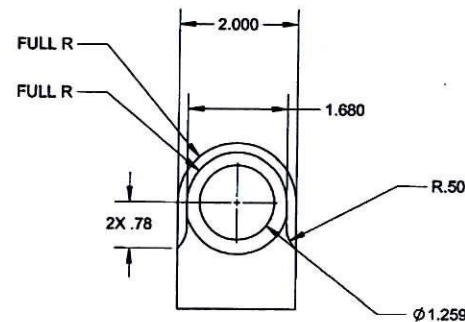
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____ Descripti _____	S034596 Clamp PART NO: RBW6205G25031 – 3G – 1 Original Serial #: S034596 Revision: Operation: Start up Operation Change No:			Dart Aerospace Ltd. 1278 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	MRB (QSI042) Approval _____ Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																
<table style="width:100%;"> <tr> <th colspan="2">Root Cause</th> </tr> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-v. ☐ Operato ☐ Offset/S ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>	Root Cause		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-v. ☐ Operato ☐ Offset/S ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%;"> <tr> <td style="width:33%;"> Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%;"> Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%;"> ss/Surge gram ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>			Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	ss/Surge gram ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	01/23/18 Job No: 168583										
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OTHER : _____																					

8 7 6 5 4 3 2 1

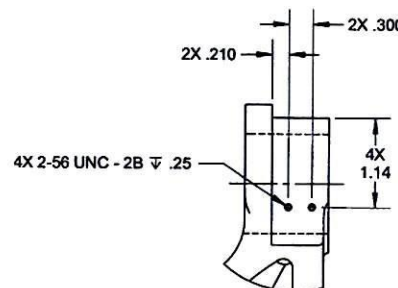


CAP 5 TON

6



SECTION A-A



DETAIL B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 168583 MCD
1711-17

- NOTES:
- 1) MATERIAL: ENERPAC A-205, MODIFIED
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: INK STAMP "RBW6205G25031-3G" AND S/N

RBW6205G25031-3G-1 CLAMP ASSY

DART AEROSPACE Markham, Ontario, Canada	
TITLE CLAMP ASSY	
DATE 18/10/2017	REV B
PART NO. RBW6205G25031-3G-1	
DESIGN BY: DPD 16/05/2017	CHECKED BY: SAC 10/18/2017
DRIVEN BY: SAC 10/18/2017	INFO APPR: DP 10/18/2017
APPROVED BY: WM 10/26/2017	DATE: 18/10/2017
SCALE: NTS	WEIGHT: N/A
SHEET 2 OF 3	
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8 7 6 5 4 3 2 1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. <u>RBW6205626031</u>		Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐			
NCR No. _____		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐			
		Use-as-Is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			
		Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐				
Date: <u>JAN 16/2018</u>	Step #: _____	QTY Effective: _____				MRB (QS1042) Approval <u>1/16/18</u>			
Description Work Order Deviation				Disposition				Completed By	
RBW6205626031 HAS 1 ADDITIONAL HOLE DRILLED (#2-66UNC)				ADDITIONAL HOLE HAS NO EFFECT ON PART - ACCEPTABLE TO RELEASE AS IS, OR FILL HOLE WITH EPOXY. ALTERNATIVELY USE 0.06" THICK LAYERS OF PR 890/1422 IN PLACE OF -3 AND QTY (4) FASTENERS. *SEE ORDER				Lead hand / Supervisor Approval Verification <u>20 18-01-23</u>	
								QC / QA Coordinator Approval <u>20 18-01-23</u>	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER: _____							

H:/FORMS/Quality Assurance/approved QA/NCRWO Rev I

* APPLY WPS 2 OR WPS 3 TO
ALL BARE METAL SURFACES